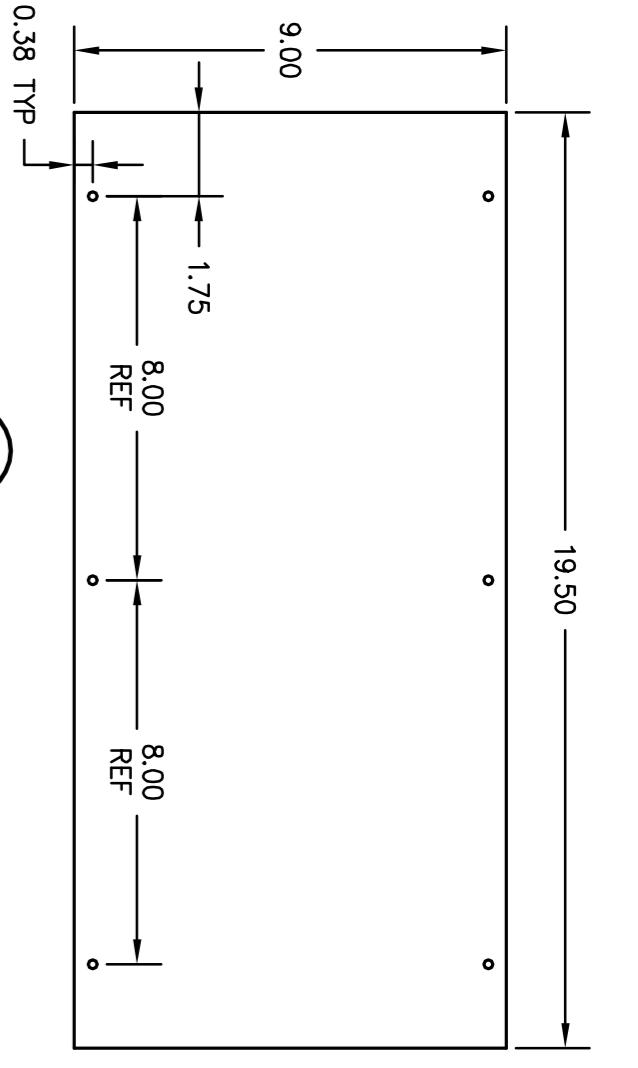


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REV. 0

INITIAL ISSUE - CREATED FROM 94012 REV. 1

DATE 04/02/2016

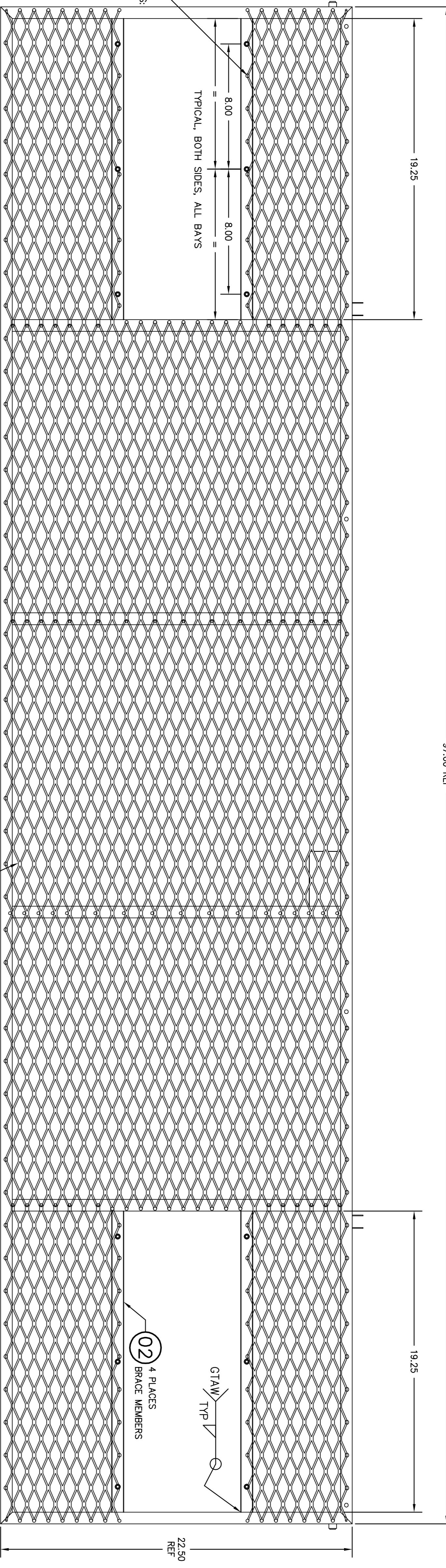


⑤ COVER

HOLE LOCATIONS TO MATCH BUSHINGS IN LID

DRILL 5/16 (0.313) THRU CENTERED ON TUBE ④
ATTACHMENT OF MESH TO BRACES: WELD EACH INTERSECTION

GTAW TYP
TYPICAL, BOTH SIDES



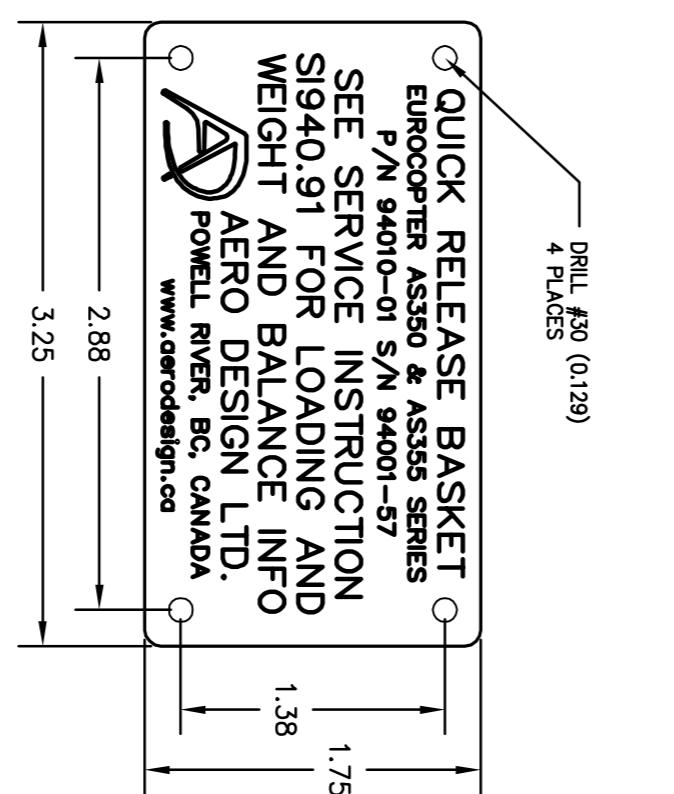
③ MESH

GTAW TYP
TRIM MESH AROUND BUSHINGS
TYPICAL, BOTH SIDES, ALL BAYS

TYPICAL, ALL BUSHING LOCATIONS

DETAIL C

SCALE 1:1



⑥ PLACARD

SCALE 1:1

ENGRAVE 0.007 DEEP AS FOLLOWS:
"QUICK RELEASE BASKET" - 0.25 HIGH
"P/N 94010-01 S/N 94001-57"
"SEE SERVICE INSTRUCTION"
"SI 940.91 FOR LOADING AND
WEIGHT AND BALANCE INFO"
"SI 940.91 FOR LOADING AND"
"WEIGHT AND BALANCE INFO" - 0.125 HIGH
"AERO DESIGN LTD." - 0.125 HIGH
"POWELL RIVER, BC, CANADA" - 0.080 HIGH
"www.aerodesign.ca" - 0.080 HIGH

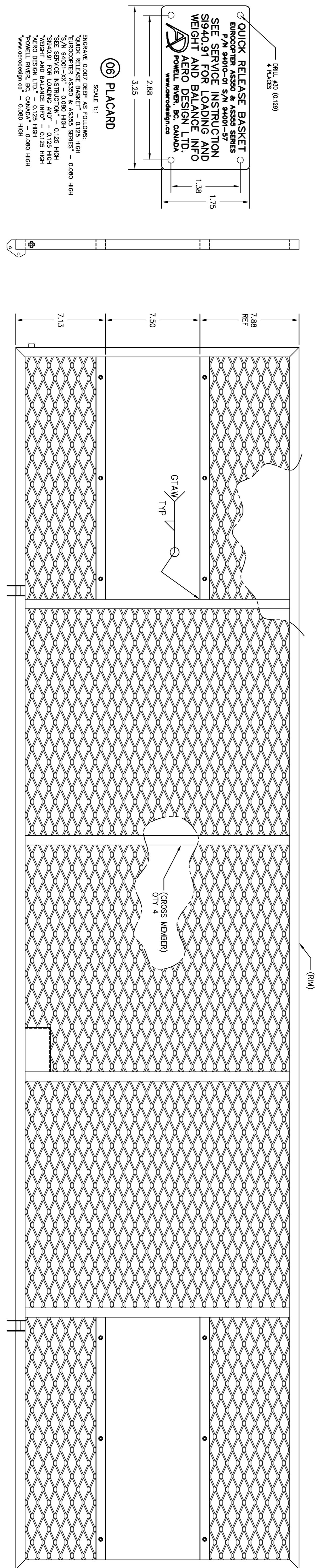
NOTES:

1. THIS DRAWING IS A MODIFICATION TO INCORPORATE OPENINGS IN THE LID TO PROVIDE ACCESS PORTS FOR SURVEY EQUIPMENT. REMAINDER OF CONSTRUCTION REMAINS IN ACCORDANCE WITH DRAWING 94012, REVISION 1.
2. LID MAY BE MODIFIED WITH A WALKWAY ON THE UNMODIFIED BAYS IN ACCORDANCE WITH DRAWING 70405, REVISION 4, AND MAY BE ALIGNED WITH THE CUTOUT SUPPORTS.
3. COVERS (05) TO BE INSTALLED USING AN3 BOLTS, NAS1149-0363JP WASHERS, MS2104-AN3 NUTS IN ALL LOCATIONS PROVIDED AFTER FINISH IS APPLIED.
4. REMOVE ALL BURRS AND BREAK SHARP EDGES.
5. PRIOR TO WELDING, DRILL #30 (0.129) VENT HOLES IN ASSEMBLY FOR VENTING OF WELD GASES. WHEN ASSEMBLY IS COMPLETE, FILL ALL EXPOSED VENT HOLES WITH ROSETTE WELD.
6. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2685C.
- 4130 AND 1018 STEEL: WELDING ROD SHALL CONFORM TO ERTOS-2 OR EQUIVALENT.
7. THOROUGHLY DEGREASE AND POWDER COAT BASKET ASSEMBLY AFTER WELDING.
- THOROUGHLY DEGREASE AND POWDER COAT COVERS.

END VIEW

① LID ASSEMBLY

TOP VIEW



② BRACE MEMBERS

GTAW TYP
ATTACHMENT OF MESH TO BRACES: WELD EACH INTERSECTION

TYPICAL, BOTH SIDES, ALL BAYS

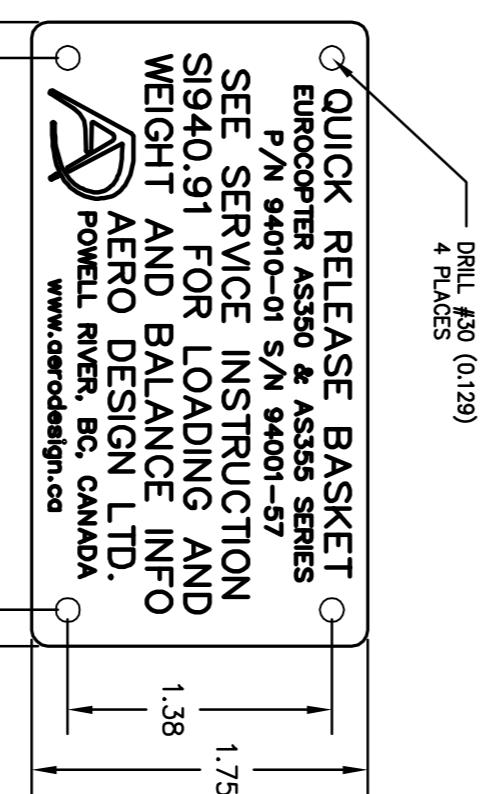
③ MESH

GTAW TYP
TRIM MESH AROUND BUSHINGS
TYPICAL, BOTH SIDES, ALL BAYS

TYPICAL, ALL BUSHING LOCATIONS

DETAIL C

SCALE 1:1



⑥ PLACARD

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QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE	LIST OF MATERIALS
1	94092-01	01	LID ASSEMBLY	X-XXX	± 0.010	X-X	